

Wednesday, July 08, 2015 3:14:58 PM

Page 1

Quality Control

~~8~~ 08/13/15

4x Sp 15-07-30 DAS 27 8-59

42 \$ 08/13/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 134448

134448

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Item ID: K10003 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Saddle

Start Date: 7/01/15 Start Qty: 4.00 *4* Cust Item ID:

Required Date: 7/07/15 Req'd Qty: 4.00 *4* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>SHIP</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MF 15-8-13

ML5 AUG 13 2015

MF 15-8-13

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OTHER : _____																					

Picklist Print

Wednesday, July 08, 2015 3:14:55 PM

Page 1

Work Order ID: 134448

134448

Parent Item: K10003

K10003

Parent Item Name: Saddle

Start Date: 7/01/15

Required Date: 7/07/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF
 IPP: J 06-07-25 As per DSI 9344 JLM
 IPP: K 06.11.17 Per K10003 Rev C KJ
 IPP: L 07.01.12 Document Record for copying bluefile rmv KJ
 IPP Rev: M 08-08-12 now @ chg 006 (DSI 9418) DD verified by:
 IPP N 09.01.27 DSI 9418 rev B EC verified by: DD IPP Rev: O
 11.03.11 per dsi9536 DD verf: EC IPP REV: P 12.01.23 AS
 PER ECN11-684 VERF: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-51A		Purchased	No			110	Each	255.0000	8	32		DAS 27 9-59	DAS 26 9-89
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AN4-51A

Bolt

**

Location	Loc Qty	Loc Code
FG	5	
122993	5	
ST312A	250	
m131305	1	
m131624	49	
m132344	50	
m132536	75	
m132551	75	

JUL 30 2015

[Handwritten signature]

 9x.
 #23x

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Work Order ID: 134448

134448

Parent Item: K10003

K10003

Parent Item Name: Saddle

Start Date: 7/01/15

Required Date: 7/07/15

Start Qty: 4.00

Required Qty: 4.00

AN4-6A

Purchased

No

110

Each

1,160.000

16

64

AN4-6A

BOLT

[Handwritten signature]

Location

Loc Qty

Loc Code

CA

143

M128403

43

M130851

100

ST325A

1009

9231

12

M131153

997

ST345

8

M128403

8

**

DAS
26
9-89

CoX.

AN4C46A

Purchased

No

110

Each

387.0000

4

16

AN4C46A

Bolt

[Handwritten signature]

Location

Loc Qty

Loc Code

FG

6

123642

2

m132169

4

ST312A

311

131651

0

m129431

100

m129505

1

m131856

70

m132381

70

m132522

70

ST341

70

131651

70

**

DAS
26
9-89

JUL 30 2015

CoX.

DQA: _____ Date: _____



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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal/Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐																								
Misidentified ☐	Past Due ☐	OTHER : _____																							

Picklist Print

Wednesday, July 08, 2015 3:14:55 PM

Work Order ID: 134448

134448

Parent Item: K10003

K10003

Parent Item Name: Saddle

Start Date: 7/01/15

Required Date: 7/07/15

Start Qty: 4.00

Required Qty: 4.00

AN6-12A

Purchased

No

110

Each

195.0000

8

32

~~AN6-12A~~

Bolt

**

DAS
26
9-89
27
9-89

Location

Loc Qty

Loc Code

ST286A

152

131677

75

M129507

17

M131957

60

ST335

43

M132536

43

5x.

24x

D2570

Manufactured

No

110

Each

297.0000

24

96

~~D2570~~

Bushing

**

B134382.600x.

DAS
26
9-89
27
9-89

Location

Loc Qty

Loc Code

FG

12

88781

12

FP001

147

133432

147

ST008

4

116925

4

ST012a

134

129830

34

132548

100

360x.

D2571

Manufactured

No

110

Each

13.0000

1

4

~~D2571~~

Saddle, Fwd, Out

**

J.A.

DAS
26
9-89
27
9-89

Location

Loc Qty

Loc Code

ST397

9

130850

9

ST405

4

119178

4

4

6134749

JUL 30 2015

Wednesday, July 08, 2015 3:14:56 PM

Shop Packet Print

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By																																																									
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								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Page 4

Wednesday, July 08, 2015 3:14:56 PM

Work Order ID: 134448

134448

Parent Item: K10003

K10003

Parent Item Name: Saddle

Start Date: 7/01/15

Required Date: 7/07/15

Start Qty: 4.00

Required Qty: 4.00

DAS
26
9-89

D2572

Manufactured No

110

Each

20.0000

1 4

D2572

Saddle, Fwd, In

**

JA

DAS
27
9-89

Location

Loc Qty

Loc Code

ST397

16

131069

16

ST405

4

119179

4

D2573

Manufactured No

110

Each

4.0000

1 4

D2573

Saddle, Aft, Out

**

JA

DAS
26
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST405

4

119180

4

D2574

Manufactured No

110

Each

9.0000

1 4

D2574

Saddle, Aft, In

**

JA

AUG 12 2015

DAS
26
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST398

5

128969

1

131143

4

ST405

4

119181

4

J

8134752

4

JUL 30 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
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Root Cause				FAULT CATEGORY																					
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐																								
Misidentified ☐	Past Due ☐	OTHER :																							

Picklist Print

Page 5

Wednesday, July 08, 2015 3:14:56 PM

Work Order ID: 134448

134448

Parent Item: K10003

K10003

Parent Item Name: Saddle

Start Date: 7/01/15

Required Date: 7/07/15

Start Qty: 4.00

Required Qty: 4.00

D2747

Manufactured No

110

Each

127.0000

4

16

D2747

Set Screw

**

DAS
26
9-89
DAS
27
9-89

Location

Loc Qty

Loc Code

ST010

27

119525

5

133459

22

ST012a

100

127549

50

131867

50

16x

D2876

Manufactured No

110

Each

39.0000

2

8

D2876

Saddle Spacer

**

DAS
26
9-89

Location

Loc Qty

Loc Code

ST025A

39

120246

1

128431

38

8x

D2877

Manufactured No

110

Each

64.0000

2

8

D2877

Saddle Spacer

**

DAS
26
9-89
DAS
27
9-89

Location

Loc Qty

Loc Code

ST013

10

133170

10

ST025A

54

119598

2

128495

40

131919

12

6x
2x

JUL 30 2015

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Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
										QC / QA Coordinator Approval															
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

Picklist Print

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Work Order ID: 134448

134448

Parent Item: K10003

K10003

Parent Item Name: Saddle

Start Date: 7/01/15

Required Date: 7/07/15

Start Qty: 4.00

Required Qty: 4.00

DAS
26
9-89

D3405-041

Manufactured No

110

Each

38.0000

4

**

4x 134753

~~D3405-041*~~

Gh Lug

Green J

Location

Loc Qty

Loc Code

st529

38

119182

7

119471

31

D3405-043

Manufactured No

110

Each

11.0000

4

**

4x B 134754

~~D3405-043*~~

Gh Lug

Green J

Location

Loc Qty

Loc Code

ST531

11

119183

11

D3407-041

Manufactured No

110

Each

25.0000

1

4

**

JA

~~D3407-041*~~

Tow Ring

Green J

Location

Loc Qty

Loc Code

st530

20

133789

20

ST532

5

107840

3

119184

2

B134755

DAS JUL 30 2015
27
9-89

Wednesday, July 08, 2015 3:14:57 PM

Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					

Picklist Print

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Wednesday, July 08, 2015 3:14:57 PM

Work Order ID: 134448

134448

Parent Item: K10003

K10003

Parent Item Name: Saddle

Start Date: 7/01/15

Required Date: 7/07/15

Start Qty: 4.00

Required Qty: 4.00

D3417-5

Manufactured No

110 Each

94.0000

2 8

**

DAS

DAS
26
9-89

D3417-5

Washer

[Signature]

Location

Loc Qty

Loc Code

ST038

1

124382

1

ST038A

93

129948

11

131054

42

133476

40

81

DAS
27
9-89

D3456-1

Manufactured No

110 Each

45.0000

4 4

**

DAS

DAS
26
9-89

D3456-1

Washer

[Signature]

Location

Loc Qty

Loc Code

FG

7

25701

7

ST051A

38

128456

3

130974

35

4X

DAS
27
9-89

D3533-1

Manufactured No

110 Each

54.0000

2 8

**

DAS

DAS
26
9-89

D3533-1

Set Screw

[Signature]

Location

Loc Qty

Loc Code

ST048

54

128448

6

132547

48

8X

DAS
27
9-89

JUL 30 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, July 08, 2015 3:14:57 PM

Work Order ID: 134448

134448

Parent Item: K10003

K10003

Parent Item Name: Saddle

Start Date: 7/01/15

Required Date: 7/07/15

Start Qty: 4.00

Required Qty: 4.00

DAS
26
9-89

MS21042L4

Purchased

No

110

Each

4,028.000

24 96

MS21042L4

**

DAS
27
9-89

Locknut



Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

150

m127813

150

ST260a

3688

m130799

56

m131803

6

m132262

626

m132382

3000

96x

ST305

188

m128300

16

m130388

7

m130922

97

m131618

12

m132123

56

MS21043-4

Purchased

No

110

Each

874.0000

21 20

MS21043-4

**

DAS
27
9-89

Nut



Location

Loc Qty

Loc Code

FG

40

104603

40

GA

216

m128798

216

ST260a

400

m132536

400

20x

ST304

218

m128818

34

m131697

9

m132382

175

JUL 30 2015

Wednesday, July 08, 2015 3:14:58 PM

Shop Packet Print

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Page 9

Wednesday, July 08, 2015 3:14:58 PM

Work Order ID: 134448

134448

Parent Item: K10003

K10003

Parent Item Name: Saddle

Start Date: 7/01/15

Required Date: 7/07/15

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0463J

Purchased

No

110

Each

4,433.000

32

128

NAS1149D0463J

WASHER

**

Location

Loc Qty

Loc Code

DAS

27

9-89

DAS

28

9-89

GA

41

M129390

41

ST260a

1000

M132677

1000

ST269

3392

M128591

16

M129682

86

M130799

371

M132035

2762

M132317

157

128x

NAS1149D0663J

Purchased

No

110

Each

1,534.000

8

32

NAS1149D0663J

Washer

**

JUL 30 2015

Location

Loc Qty

Loc Code

DAS

27

9-89

DAS

28

9-89

ST260

467

M131618

467

ST260a

1000

M132256

1000

ST269

67

M126334

67

32x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																		
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OTHER : _____																																																																						

5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		(1)		X		D205-634-045	SKIDTUBE
	1	(1)			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		NAS1149D0332J	* WASHER (AN960JD10L)
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		NAS1149C0332R	* WASHER (AN960C10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	(1)				D2571	SADDLE, FWD OUTSIDE
21	1	(1)				D2572	SADDLE, FWD INSIDE
22	1	(1)				D2573	SADDLE, AFT OUTSIDE
23	1	(1)				D2574	SADDLE, AFT INSIDE
24	8	(8)				AN4-51A	BOLT
25	16	(16)				D2570	BUSHINGS
26	8	(8)				MS21042L4	NUT (OR MS21042-4)
27	8	(8)				AN6-12A	BOLT
28	8	(8)				NAS1149D0668J	WASHER (AN960JD616)
29	16	(16)				AN4-6A	BOLT
30	32	(32)				NAS1149D0463J	WASHER (AN960JD416)
31	16	(16)				MS21042L4	NUT (OR MS21042-4)
32	4	(4)				D2747	SET SCREW
33	2	(2)				D3533-1	SET SCREW
40	1	(1)				D3407-041	TOW RING (REPLACES D2968-041)
41	1	(1)				D3456-1	WASHER
43	1	(1)				MS21043-4	NUT
44	2	(2)				D3417-5	WASHER
50					1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51					1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52		(4)			4	AN4C46A	BOLT
53		(8)			8	D2570	BUSHING
54		(4)			4	MS21043-4	NUT (OR MS21042-4)
60	2	(2)				D2876	SADDLE SPACER
61	2	(2)				D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH D2580-041/-045 ASSEMBLY ABOVE

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Revision: H
Date: 14.04.11

DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-634 Rev. 3

REF. CANADIAN STC: SH96-88

REF. FAA STC: SR00563NY

REF. EASA STC: EASA.IM.R.S.01303

PURPOSE:

The parts list of Instructions for Continued Airworthiness ICA-D205-634 Rev. 3 lists the incorrect washer for the D3407-041 Tow Ring Assembly. The correct washer is the D3417-5 Washer, which has a groove to fit the ridge on the sides of the Dart skidtube.

CHANGE:

The parts in section 32.9 (pg. 35) of ICA-D205-634 Rev. 3 is amended as follows:

ITEM	634 -011	634 -015	634 -041	634 -045	641 -011	PART NUMBER	DESCRIPTION
	X					D205-634-011	SKIDTUBE INSTALLATION, (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION, (MODIFIED)

IS:

44	2	2				D3417-5	WASHER
----	---	---	--	--	--	---------	--------

WAS:

44	2	2				D3417-3	WASHER
----	---	---	--	--	--	---------	--------

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.06.30
CERT. NO.: SH96-88
ISSUE NO.: 3

A	NEW ISSUE , REF CAR 09-001	CP	09.06.30
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9468	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		PARTS LIST CORRECTION	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	